

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017830**Date Inspected:** 05-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, 11BW-11CW, DP-A2.

SMAW Repair welding (Ultrasonic Inspection repair per AB/F UT-report # UT-11W-054) of weld joint OBW11-007 (WRR # B-WR16554); located at Trial assembly yard. Welders are identified as 040611; ZPMC Quality Control Inspector (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The attached photographs provide additional detail.

Trial assembly yard, 11DW-11EW, SP transverse splice.

FCAW welding of weld joint OBW11C- 001; located at Trial assembly yard. Welders are identified as 049220; ZPMC Quality Control Inspector (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233T.

Trial assembly yard, 11CE-11DE, EP-B3, Bike Path Side.

FCAW welding of weld joint OBE11A- 005; located at Trial assembly yard. Welders are identified as 049515; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector carried out NDE on following

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Trial assembly yard, 11BW-11CW.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-11W-048R1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Side panel & Edge panel at the intersection of OBG Segment 11BW- 11CW, Counter weight Side. The weld designations were as;

- 1) CA083-005. (11BW-11CW, SP-EP-W1);
- 2) CA085-001. (11BW-11CW, SP-EP-W1).

Trial assembly yard, 11AE-11BE, T-rib splice, UT after repair.

This QA inspector performs Random Ultrasonic Testing (UT) of UT repair area previously tested and accepted by ZPMC Quality Control personnel (Notification # 07243). This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as

- 1) BP186-001-026. UT after repair
- 2) BP078-001-020. UT after repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

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Reviewed By: Dsouza,Christopher

QA Reviewer